



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4072-1
Job Sheet 198427

Part No: D4072-1 **Job Qty:** 20 pcs
Part Name: Airframe Hinge

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 7/29/19 **Job Tracking No:**
Due Date: 8/23/19 **Created By:** Jennifer Renwick
Type: Stock **Description:**
Note: DWG REV B SHEET 1 Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	8/23/19	8/23/19	0.00	0.29	Bandsaw - 1		mmcl 19/08/19
105	HAAS 4 Axis - B4B	20 pcs	8/23/19	8/23/19	0.20	8.89	HAAS - 1 - B4B		mmcl 19/08/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	QC 2	20 pcs	8/23/19	8/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mmcl 19/08/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

DART
AEROSPACE
Container No: S207795

Part: D4072-1
Job No: 198427
Serial No/Batch: S207795
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/19

120 QC 8	20 pcs	8/23/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
150 Handfinish - 1-1 Chemical-B4B	20 pcs	8/23/19	0.00 0.37	QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	LA 19-08-21
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	BE B 19-08-22
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	

					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 Powdercoat - 2 White GI(S)- B4B <i>M 103459</i>	20 pcs	8/23/19	0.00 0.35		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170 QC 3	20 pcs	8/23/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180 Packaging 3-1 - Stock - B4B	20 pcs	8/23/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

BR 19-8-22

START: 1:00 O.V.T: 3:00 FINISH: 1:30

*DAS 40
ATG 2 2 2019 9-89*

WL ST72

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	8/23/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	AUG 26 2019 70
				QC 21 - SA - 53	9-89
Part Op 100 - (Bandsaw) Descriptions: 105 - (HAAS CNC Vertical Machine) 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location:) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X02.500	6061-T6 Bar 1.00 X 2.50	2.0800 ft (.104 ea)	100-Bandsaw - 1	S172190	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X02.500	2	4	0	
Part Specifications					
Specifications could not be found.					

MATT
WLD
2-106
2-003

DART AEROSPACE LTD		Work Order:	198427
Description: Airframe Hinge		Part Number:	D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	501 X .122	/		vern	none - 05
2.00	+/-0.030	2.003	/		✓	
Ø0.203	+0.005/-0.001	.204	/			
0.750	+/-0.010	.749	/			
R0.06	+/-0.030	.06	/			
0.45	+/-0.030	.45	/			
1.100	+/-0.010	1.101	/			
R0.38	+/-0.030	.38	/			
0.375	+/-0.010	.375	/			
0.688	+/-0.010	.683	/			
0.275	+/-0.010	0.274	/			
R0.13	+/-0.030	.13	/			
0.25	+/-0.030	.247	/			
1.06	+/-0.030	1.056	/			
0.125	+/-0.010	.125	/			
0.86	+/-0.030	.086	/			
Ø0.323	+0.005/-0.001	.323	/		✓	

Measured by: <i>amr</i>	Audited by: <i>BA</i>	Preliminary Approval:
Date: 19/08/20	Date: 19-08-21	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	<i>[Signature]</i>
B	11.10.13	Dimension 0.25 removed	KJ	<i>[Signature]</i>